

Date: Wednesday, 3/8/2006 10:38:22 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL TUBE
Job Number	: 26119		
Estimate Number	: 12312		
P.O. Number	: N/A	Part Number	: D34735
This Issue	: 3/8/2006 S.O. No. : N/A	Drawing Number	: D3473 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below.</u>	Due Date	: 3/31/2006
Checked & Approved By	: <u>06.03.08</u>	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 06-03-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 00000768 06/03/09
 E-mail or Ship DXF file to vendor
 Laser cut flat pattern as per Dwg D3473
 Possible supplier: Ind. Laser
 Material release note is required.

2.0	D34735F	VERTICAL TUBE FLAT PATTERN
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Comment: Qty.: 1.0000 sf(s)/Unit Total : 6.0000 sf(s)
 FLANGE PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur if necessary.

Spot weld after
 2-Roll & Bead as per Dwg D3473

SB

06/04/24

(9)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		One taken for template	VJ	000322	1	VJ 0322	VJ 000329

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUBE

Job Number: 26119

Part Number: D34735

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Spot weld as per Dwg D3473

6.0

QC5/9/

WELD INSPECTION



Comment: WELD INSPECTION

AD 06-01-23 (9)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AD 06-04-26 (2)

Job Completion



Level 21 inspection

U 06-04-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

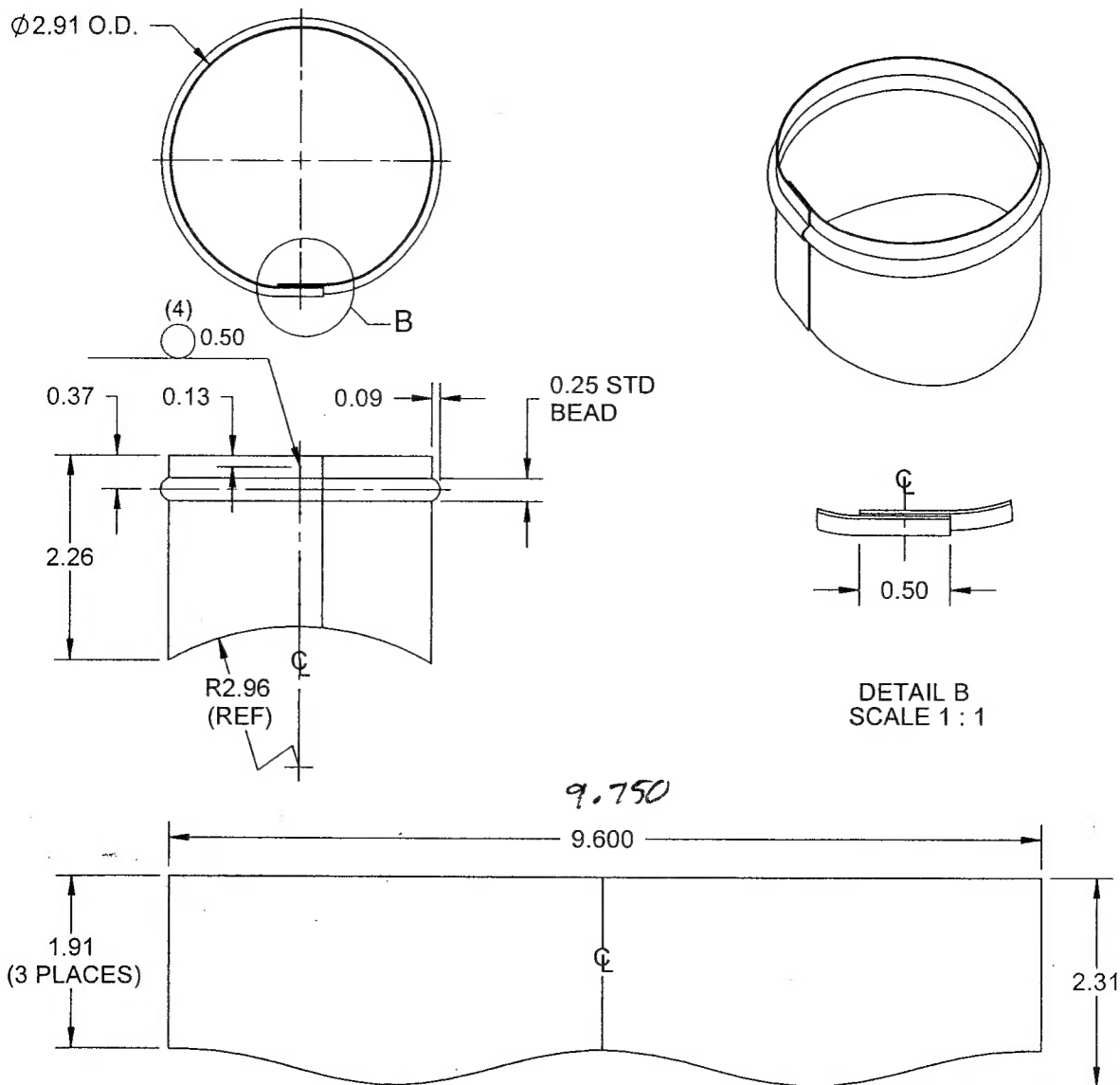
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3473	REV. A SHEET 5 OF 7
DATE 06.02.07	TITLE BLOWER INLET ADAPTER SCALE 1:2		



D3473-5F VERTICAL TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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0606-002-092

T-126 P-007/016

Fax Server

PAGE 001/002

3/17/2006 1:57

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☒ 002
☒ 001/004

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0606-002-092

T-126 P-007/016

Fax Server

PAGE 001/002

3/17/2006 1:57

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Fax Server

T-726 P.008/015 F-527

002/004

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K9
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 40TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 PRM, AMS5513H X MRK&FIN, MILS059D, AMD3, X CRWN MEAS
CORROSION: ASTM A262/02aB; 180Bend-OK
Buyer Part: 4288441
304 2B 1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O	UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV			
Tensile Strength (UTS)	93.3	KSI	F	TRANSV			
Rockwell B	85		F	TRANSV			
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV			
Rockwell A	85		T	TRANSV			

Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

Comments

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q08763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GURUPH, ONN K123
Control #: 50C60214
Part #: 74270441
.135 X .48 X .96

Date: 03/17/06

SOLD TO: INDA LAFER

TO 110880

S/O 90-374786 - 02

[Signature] 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.